

Work Order ID 115328

March-25-14 9:58:48 AM

115328

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop *NS2*

Start Date: 3/25/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/08/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-03-25 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2750-042	G
-----------	---

D3492	C
-------	---

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle: 89.8°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS

27

9-89

4/5/26

BE 14/04/02

B115328 R+1

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/08/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail J to 0.297" (total of 2 holes per side)

04
BE14-02-02

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Revision ID: Stop *NS2*

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Start Date: 3/25/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 4/08/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: M128385

BE 14/04/07

12-Grind welds flush as per Dwg D2750

120 QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Quality Control

Memo

0.00

① 14-04-07

DAS
9
9-89

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Quality Control

Memo

0.00

① 14-04-07

DAS
9
9-89

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Quality Control



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 Start Date: 3/25/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/08/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 128526
exp. date: 11-10-09

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M128385

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750 14-4-15 JLL/BE

11-Spot face ground handling holes section (total of 4 places per side) as per 14-4-16 DGL

DC 14/04/08

DGL/JLL

14-4-8

BE1404-15

14-4-16 DGL

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 Required Date: 4/08/14 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								
	12-Deburr holes								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								

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 Required Date: 4/08/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1		76/1453	
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00				1		CR 1405-4	
200									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 128979 128979								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: m128 840								
210	QC14- Inspect Spray Paint	0.00				1RH	d	22	12/05/14
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

DAS
15
9-89

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

230

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11128569

EXP DATE: 12/16

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11121651

5-Coat all exposed fasteners with "LPS Procyon"

batch: 11122900

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

DAS

27

3/29

14/5/16

1134 d 11128569

NAS 1611-013 / M128375 x8

NAS 1611-010 / M128375 x8

PLM 14-06-03

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 3/25/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/08/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									DAS
Packaging	Memo	0.00				1			33 14-05-23 9-89
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									DAS
QC	Memo	0.00							27 9-89
Quality Control									14/5/26
270	Packaging	0.00							
270									
Packaging	Memo	0.00				1	SL		14-06-10
Packaging	Package as per PPP D350-636-012								SL

FG 072

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Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/08/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLS 14-06-10

14-6-10

Picklist Print

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Work Order ID: 115328

115328

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I02.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	6.0000	1	1			
D2600-3-BFNT									**				
Extrusion Bent													
				<u>Location</u>				<u>Loc Qty</u>					
				LG				6					
				111091				5					
				111606				1					
D2744		Manufactured	No			110	Each	10.0000	1	1			
D2744									**				
Cap													
				<u>Location</u>				<u>Loc Qty</u>					
				LG001				10					
				100398				10					

BE14/04/02
 B112976 *1

BE14/04/07
 B115440 *1

Picklist Print

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Work Order ID: 115328

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No 160 Each 28.0000 1 1

D2739

350 I Beam

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	21	
110835	1	
111094	9	
111609	1	
113252	10	
LG002	7	
112596	7	

D2743 Manufactured No 160 Each 247.0000 8 8

D2743

Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	246	
111570	125	
112729	121	
LG001	1	
109799	1	

D3490-3 Manufactured No 160 Each 88.0000 4 4

D3490-3

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	88	
112736	88	

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Work Order ID: 115328

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

121.0000

4

4

D3490-1

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG

37

112737

37

LG001

84

109932

84

D3631-1

Manufactured No

230

Each

176.0000

8

8

D3631-1

Washer

**

Location

Loc Qty

Loc Code

FP001

176

110258

16

111019

60

113164

100

D3791-1

Manufactured No

230

Each

22.0000

1

1

D3791-1

Wearpad

**

Location

Loc Qty

Loc Code

FP002

22

110982

19

112413

3

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No 230 Each 21.0000 1 1

D3793-3

Wearplate Aft

Handwritten signature and date 4/03/14

Location	Loc Qty	Loc Code
FP001	1	
104212	1	B115604
FP002	20	
110887	12	
113035	8	

Handwritten checkmarks and lines

MS21043-6 Purchased No 230 Each 326.0000 4 4

MS21043-6

NUT

Handwritten signature and date 4/05/14

Location	Loc Qty	Loc Code
FG	20	
103693	20	
ST315	56	
m127255	56	
ST509	250	
m127813	250	

Handwritten checkmarks and lines

D3794-1 Manufactured No 230 Each 27.0000 1 1

D3794-1

Gasket Fwd

Handwritten signature and date 4/05/14

Location	Loc Qty	Loc Code
FP001	27	
109207	1	
111574	13	
112521	2	
113203	11	

Handwritten checkmarks and lines

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Shop Packet Print

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Picklist Print

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

303.0000

8

8

NAS1611-010

O-RING

**

HL 11/05/14

Location

Loc Qty

Loc Code

FP001

303

m126988

3

m127813

4

m128375

288

m128388

8

V8

D2741

Manufactured

No

250

Each

17.0000

1

1

D2741

Blade

**

115522

DAS

33

9-89

14-05-23

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

6

107206

2

110710

4

NAS1515H3L

Purchased

No

230

Each

295.0000

4

4

***NAS1515H3I ***

Washer

**

HL 11/05/14

Location

Loc Qty

Loc Code

FG

36

102472

36

ST297

259

m127831

259

V4

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D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

344.0000

8

8

NAS1611-013

O-RING

**

HL 11/05/14

Location

Loc Qty

Loc Code

FP001

344

m128375

344

AN3C6A

Purchased

No

230

Each

395.0000

4

4

AN3C6A

Bolt

**

HL 11/05/14

Location

Loc Qty

Loc Code

FG

10

122416

10

ST351

42

m128224

42

ST513

343

m125709

343

NAS1149C0832R

Purchased

No

230

Each

315.0000

1

1

NAS1149C0832R

Washer

**

HL 11/05/14

Location

Loc Qty

Loc Code

ST292

315

122441

48

m114915

117

m125807

150

X 1

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

17.0000

1

1

D3536-25

Gasket Center

Handwritten: 14/05/14

Location

Loc Qty

Loc Code

FG

6

B117627

x1

87053

2

95328

4

FP001

11

110652

1

111417

9

113008

1

D3794-3

Manufactured No

230

Each

5.0000

1

1

D3794-3

Gasket Aft

Handwritten: 14/05/14

Location

Loc Qty

Loc Code

FP001

5

B115659

x1

113060

5

AN3C5A

Purchased No

230

Each

851.0000

34

34

AN3C5A

Bolt

Handwritten: 14/05/14

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

846

M128057

846

x34

Picklist Print

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

74.0000

3

3

D3537-1

Wearpad

Handwritten: ul 1103/14

Location

Loc Qty

Loc Code

FG

18

Handwritten: B113229

Handwritten: x3

79833

8

88562

10

FP001

56

113839

1

114585

55

D3535-25

Manufactured No

230

Each

25.0000

1

1

D3535-25

Wearplate Center

Handwritten: ul 1105/14

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

23

110193

1

110744

1

112385

5

113120

16

Handwritten: v1

D3492-3

Manufactured No

230

Each

172.0000

8

8

D3492-3

Plug

Handwritten: ul 1105/14

Location

Loc Qty

Loc Code

FP001

172

104853

24

107331

1

111553

47

112739

100

Handwritten: x2

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

10,470.00

38

38

NAS1149C0332R

WASHER

**

Handwritten: 44 11/05/14

Location

Loc Qty

Loc Code

GA

1033

125654

1033

ST292

5000

m128591

5000

x38

st510

4437

m126319

61

m127306

2500

m127410

1850

m127831

26

D3488-042

Manufactured

No

230

Each

5.0000

1

1

D3488-042

Blade Fitting RH

**

Handwritten: 44 11/05/14

Location

Loc Qty

Loc Code

FP001

5

13113592

106658

3

98887

2

x1

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

726.0000

38

38

ALS4-1032-225

Rivnut

**

Handwritten: 44 11/05/14

Location

Loc Qty

Loc Code

FG

30

M127028

30

M128649

x38

ST280

662

M127028

10

M128179

652

st555

34

M127092

34

March-25-14 9:58:51 AM

Shop Packet Print

Page 9

Picklist Print

March-25-14 9:58:51 AM

Page 10

Work Order ID: 115328

115328

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

176.0000

8

8

D3492-1

Plug

Handwritten: 11/03/14

Location

Loc Qty

Loc Code

FP001

176

111578

14

112738

162

Handwritten: XG

D3793-1

Manufactured No

230

Each

8.0000

1

1

D3793-1

Wearplate Fwd

Handwritten: 11/03/14

Location

Loc Qty

Loc Code

FP002

8

Handwritten: B115686

110924

8

Handwritten: X

AN8C35A

Purchased No

230

Each

80.0000

1

1

AN8C35A

Bolt

Handwritten: 11/03/14

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

76

m126293

29

m127061

1

m127823

46

Handwritten: X1

MS21083C8

Purchased No

230

Each

31.0000

1

1

MS21083C8

Nut

Handwritten: 11/03/14

Location

Loc Qty

Loc Code

ST319

31

Handwritten: 11/128798

m127255

5

m128119

26

Handwritten: Y1

March-25-14 9:58:51 AM

Shop Packet Print

Page 10

Picklist Print

March-25-14 9:58:51 AM

Page 11

Work Order ID: 115328

115328

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

274.0000

8

8

D2745

Bushing

all 1105/14

Location

Loc Qty

Loc Code

ST017

274

107336

4

110526

4

111554

124

113176

62

114874

80

18

AN6C44A

Purchased No

230

Each

82.0000

4

4

AN6C44A

Bolt

all 1105/14

Location

Loc Qty

Loc Code

FG

2

103964

2

1128700

14

ST341

80

m128319

80

D3532-1

Manufactured No

250

Each

30.0000

2

D3532-1

Spacer

DAS

33

9-89

14-05-23

Location

Loc Qty

Loc Code

ST054

30

109803

18

113225

12

109803

DAS

27

9-89

Picklist Print

March-25-14 9:58:51 AM

Page 12

Work Order ID: 115328

115328

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

31.0000

2 2

MS21083C8

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

ST319

31

m127255

5

m128119

26

**

128798

DAS
33
9-89

DAS
06
9-89

NAS1149D0863J

Purchased

No

250

Each

905.0000

2 2

NAS1149D0863J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

103

125484

103

ST510a

800

125268

600

125635

200

**

125484

DAS
33
9-89

DAS
06
9-89

D3493-1

Manufactured

No

250

Each

249.0000

2 2

D3493-1

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

239

109105

159

112741

80

**

112741

DAS
33
9-89

14-05-23

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

March-25-14 9:58:51 AM

Shop Packet Print

Page 12

Picklist Print

March-25-14 9:58:51 AM

Work Order ID: 115328

115328

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

80.0000

2

2

AN8C21A

Bolt

**

128849

DAS

33

14-05-23

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST

2

123966

2

ST341

2

m127061

2

ST342

26

m128319

26

ST508

50

m127823

50

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

TITLE

350 SKIDTUBE ASSEMBLY

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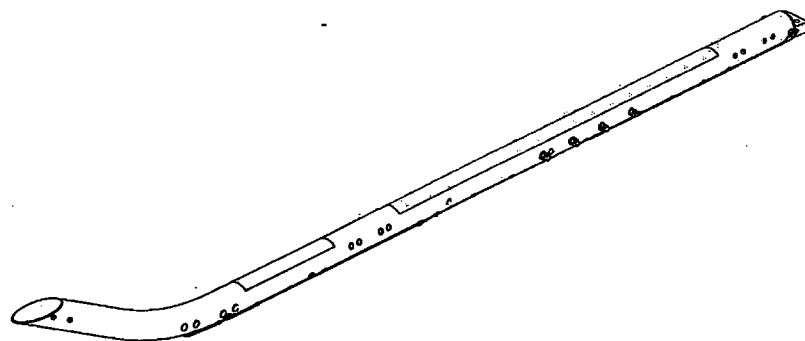
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REV. G

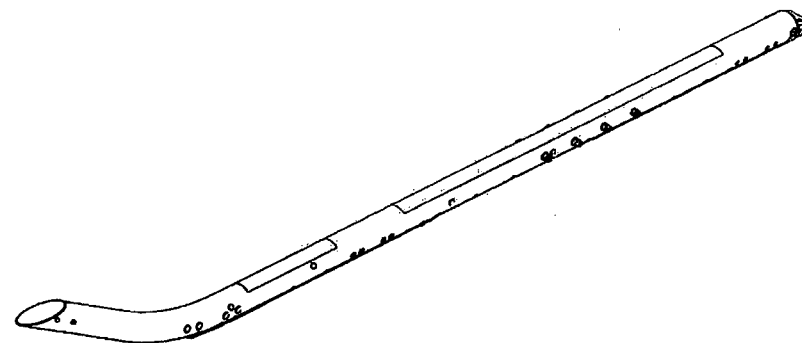
SHEET 1 OF 11

SCALE

NTS



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MP

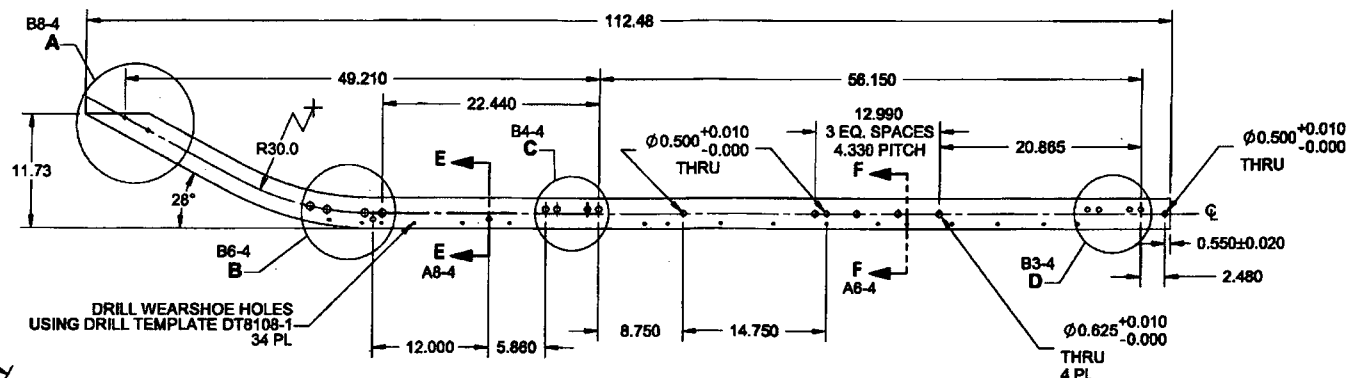
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DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

D2750-043 350 SKIDTUBE ASSEMBLY, LH

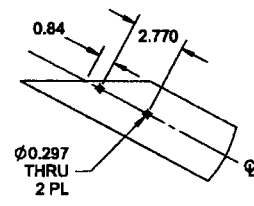
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13

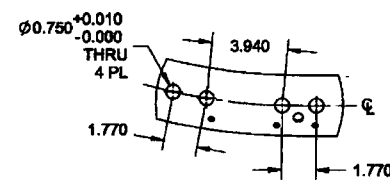
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MFG. APPR.		D2750	SHEET 3 OF 11
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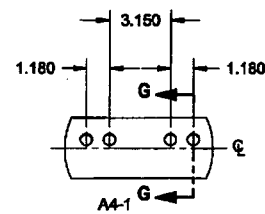
D2750-1 LH SKIDTUBE



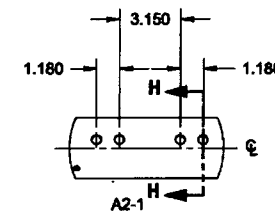
DETAIL A
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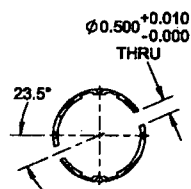
DETAIL B
SCALE 2X



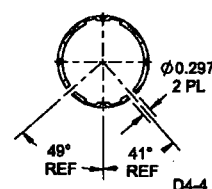
DETAIL C
SCALE 2X



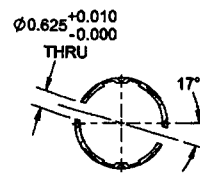
DETAIL D
SCALE 2X



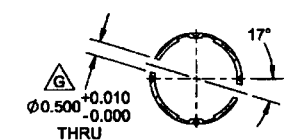
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



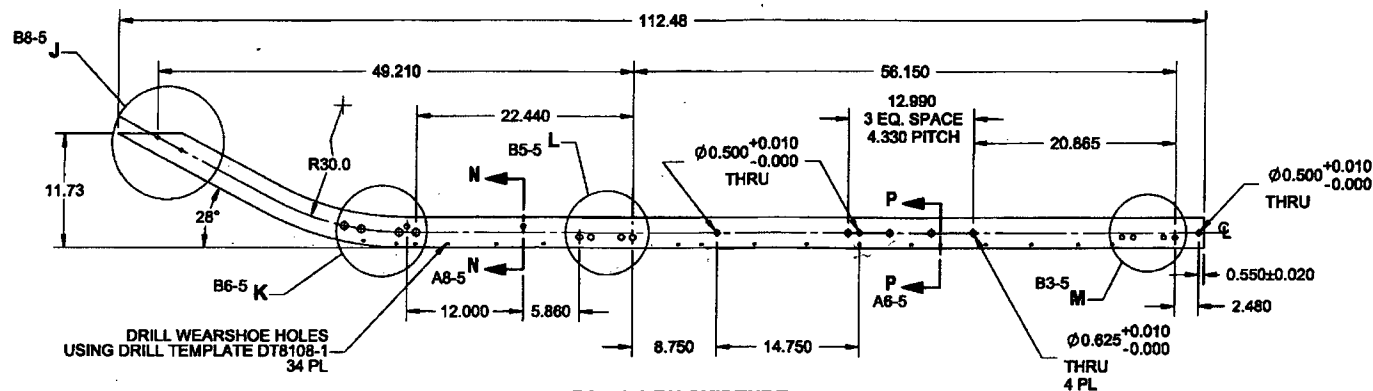
SECTION G-G
SCALE 3X, 4 PL



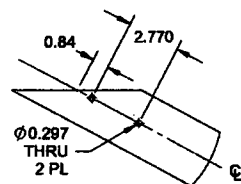
SECTION H-H
SCALE 3X, 4 PL

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2013-08-13

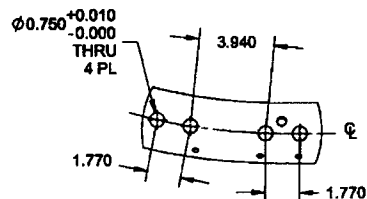
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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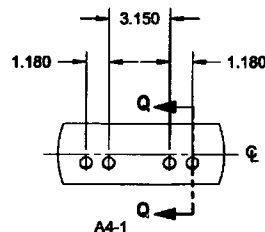
D2750-2 RH SKIDTUBE



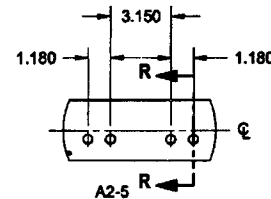
DETAIL J
SCALE 2X



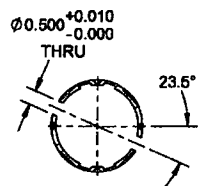
DETAIL K
SCALE 2X



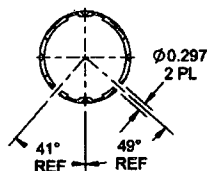
DETAIL L
SCALE 2X



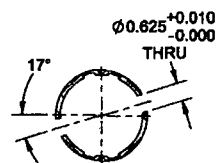
DETAIL M
SCALE 2X



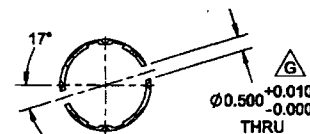
SECTION N-N
SCALE 3X, 2 PL



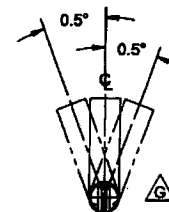
SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL








SECTION R-R
SCALE 3X, 4 PL




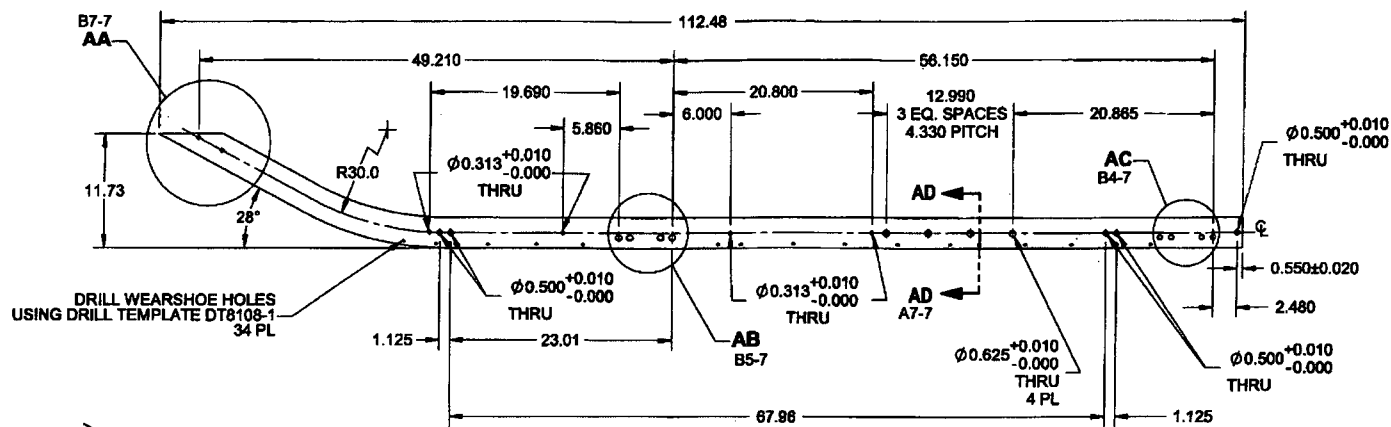
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

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2013-08-13

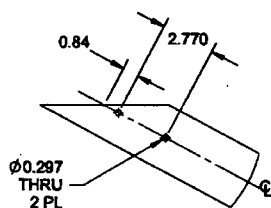
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DE APPR.		350 SKIDTUBE ASSEMBLY	NT
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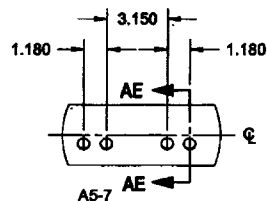
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2750	SHEET 6 OF 11
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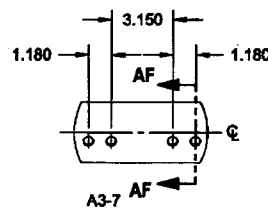
D2750-4 RH SKIDTUBE



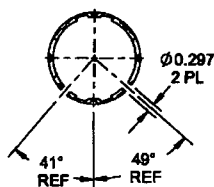
DETAIL AA
SCALE 2X



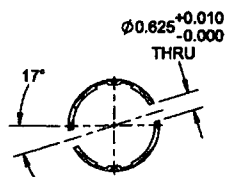
DETAIL AB
SCALE 2X



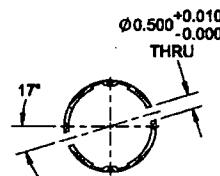
DETAIL AC
SCALE 2X



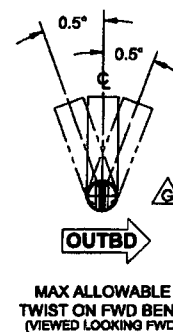
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SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
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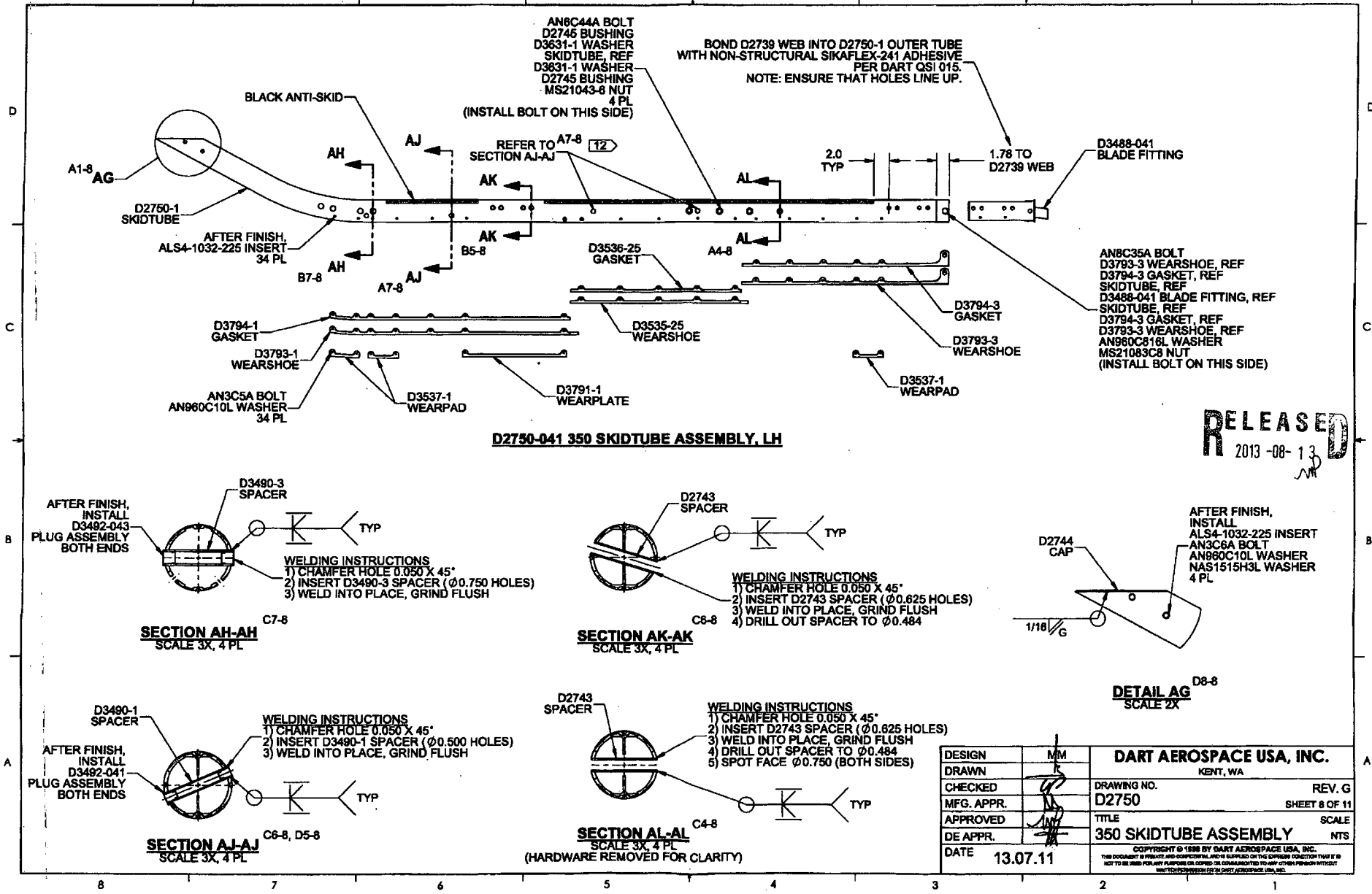


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CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. G
APPROVED		SHEET 7 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE 13.07.11		SCALE NTS

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

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SECTION AH-AH
SCALE 3X, 4 PL

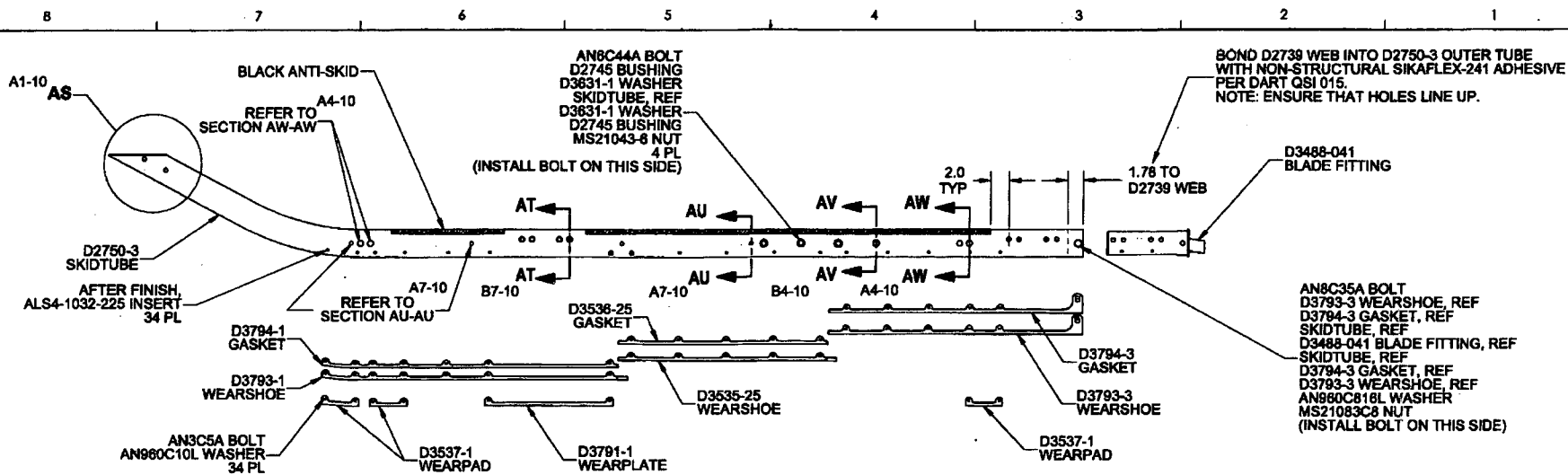
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DETAIL AG
SCALE 2X

SECTION AJ-AJ
SCALE 3X, 4 PL

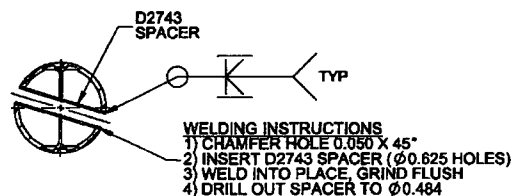
SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

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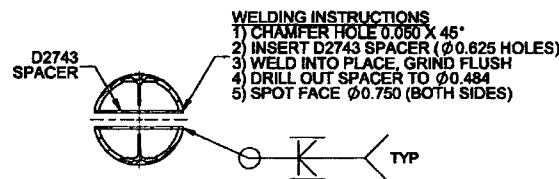


D2750-043 350 SKIDTUBE ASSEMBLY, LH

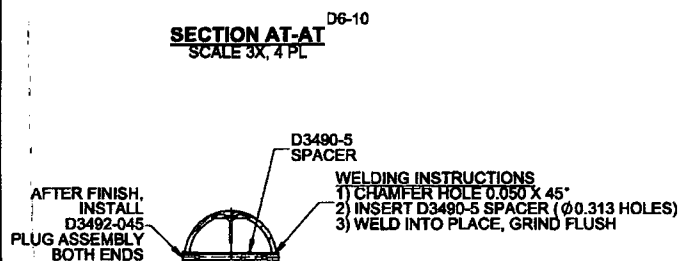
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2013-08-13



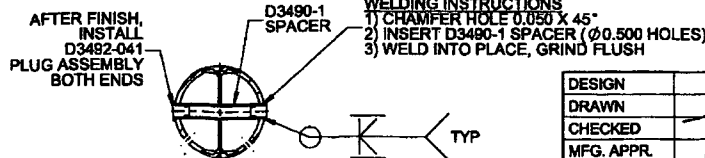
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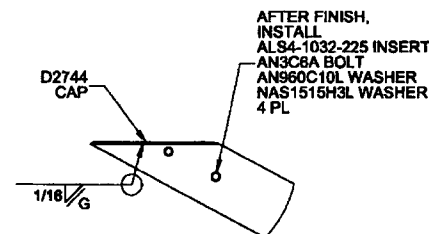
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SECTION AU-AU SCALE 3X, 4 PL



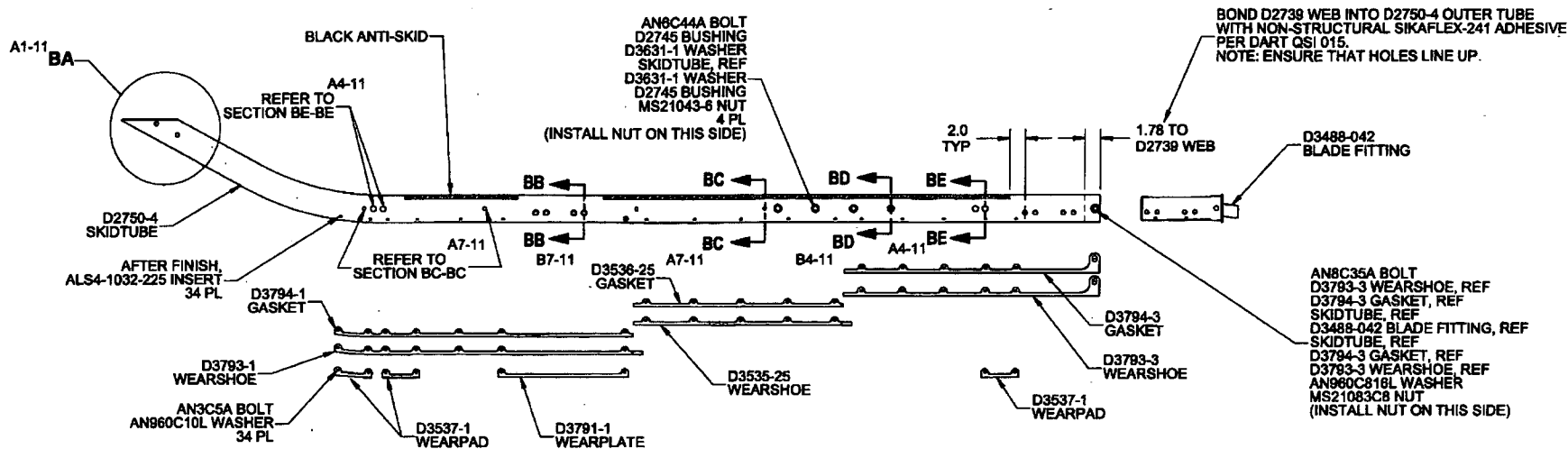
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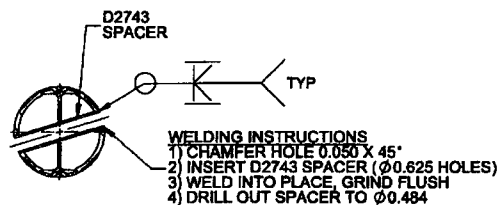
DETAIL AS SCALE 2X

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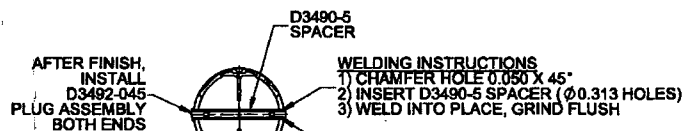
D2750-044 350 SKIDTUBE ASSEMBLY, RH



SECTION BB-BB
SCALE 3X, 4 PL



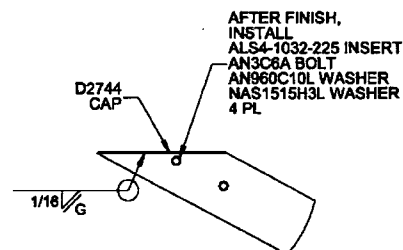
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SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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2013-08-13

Work Order ID 115328

115328

Page 1

March-25-14 9:58:48 AM

Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/08/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-03-25 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2750-042	G
D3492	C

100 Document Control 0.00

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Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

record fwd angle:

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

MLJ 14-05-23

89.4° 14-04-02